

Date: Wednesday, 08/04/2009 9:15:50 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350/355 AS X-TUBE AFT
Job Number	: 47082		
Estimate Number	: 12486		
P.O. Number	:	Part Number	: D350748201
This Issue	: 08/04/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: N/A
First Issue	: / /	Project Number	: N/A
Previous Run	: 45349	Drawing Revision	: D
	Type : CROSSTUBES	Material	:
Written By	:	Due Date	: 24/04/2009
Checked & Approved By	: <u>JUD 09.04.08</u>	Qty:	1 Um: Each
Comment	: Est Rev: A New Issue 06-07-05 JLM : Est Rev: B Update qty of MS21042L5 06-09-12 KJ : Est Rev C Combined manufacturing 08.04.02 EC verified by: DD : Est Rev: D 08-06-24 revD as per dwg DD verified by: EC : Est Rev: E 08.12.11 Step17 was step 21 KJ Verified by:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JUD 09/04/20

Comment: Photocopy bluefile & type labels per PPPD350-748-201 CHG001



2.0	D350748241TRN	Crosstube Turning Detail
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 CROSSTUBE TURNING DETAIL
 batch B-45461 MB 09-04-21 ①



3.0	BENDING	BENDING MACHINE - SKIDTUBES
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Comment: BENDING MACHINE
 Bend tube as per Dwg D350-748-241 using CNC bender program D350A and Folio FT



4.0	QC15	DIMENSIONAL CHECK OF X-TUBES
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Comment: DIMENSIONAL CHECK OF X-TUBES



5.0	CROSSTUBES	CROSSTUBES RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1



1-Drill Tube as per Dwg D350-748-241 Using DT8876 Drill Jigs,
 Set-up drill table as per QSI 010

2-Deburr

RT 09 04 -27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-748-201 PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: P Date: 09/06/08

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>47082</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09.04.23</u>	<u>3</u>	<u>ONE SIDE BENT WIDE " 41.08"</u>	<u>CP</u> <u>09.04.23</u> <u>per</u> <u>05/04/2</u>	<u>Acceptable</u>	<u>MD</u> <u>09-04-28</u>	<u>S</u> <u>08/04/29</u>	<u>CP</u> <u>09.04.23</u> <u>per</u> <u>05/04/2</u>	<u>S</u> <u>08/04/29</u>

NOTE: Date & initial all entries

Date: Wednesday, 08/04/2009 9:15:51 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE AFT

Job Number: 47082

Part Number: D350748201

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Engrave Part # and Batch # as per Dwg D350-748-241 *RT 09-04-27*

4-Remove all marks from tube within limits of D350-748-241

- AWM 9-4-28

5- Apply a light coat of LPS3 on the interior of tube

Batch:

109956 AWM 7-4-29

6.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5 08/04/28 (40)

7.0

OUTSIDE SERV.10

OUTSIDE SERVICES -skids



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O:

8099

Stress relief at 375° for 5 hours

Magnetic Particle Inspect per ASTM E1444

Cadium Plate per AMS-QQ-P-416B, Class 1, Type 2

Embrittle relief at 375° for 8 hours, Chromate Treat

Possible Supplier: Southwest United Industries

Ensure Certificate of Conformity is attached

C209/04/30 (1)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

P 9/6/2 (1)
09-06-03 (1)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside crosstube as per QSI 005 4.2

2-Paint Outside of Tube as per Dart QSI 005 4.2

RT 09-06-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE AFT

Job Number: 47082

Part Number: D350748201

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

11.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

09-06-04

12.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2401 f(s)/Unit Total: 1.2401 f(s)

✓ Abrasion Strip 7.10" long x2

Batch: 42437

RT 09-06-04

13.0

ALS41032225

Insert



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

✓ Insert

Batch: 107441

RT 09-06-04

14.0

AN960JD10

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

✓ Washer

Batch: 105442

RT 09-06-04

15.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

✓ Clamp (per MIL-DTL-8783C)

Batch: 110451

RT 09-06-04

16.0

MS27039110

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

✓ Screw

Batch: 111425

RT 09-06-04

17.0

D35021

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

✓ SUPPORT

Batch: 41603

RT 09-06-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 08/04/2009 9:15:51 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE AFT

Job Number: 47082

Part Number: D350748201

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install Ground wire Insert, then insert screw and washer

2-Install Abrasion strips as per Dwg D350-748-241 & QSI 035.

3-Install supports Using Dt8876 as per Dwg D350-748-241, Torque to 60-80 IN-LBS

} 8C 09-06-04

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0

D35001

Saddle



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

350 SADDLE

Batch: B545340

9/6/5

SL

22.0

D35011

Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

BUSHING

Batch: B44637

9/6/5

SL

23.0

AN46A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt

Batch: M109545

M110399

9/6/5

SL

24.0

AN441A

bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

bolt

Batch: M110363

9/6/5

SL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 08/04/2009 9:15:51 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE AFT

Job Number: 47082

Part Number: D350748201

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

AN532A

Bolt



9/6/5



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M109352

SL

26.0

AN960JD416

Washer



9/6/5



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Washer

Batch: M111279

SL

27.0

AN960JD516

Washer



9/6/5



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Batch: M111279

SL

28.0

MS21042L4

Nut



9/6/5



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

Batch: M110507

SL

29.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M109840

9/6/5

SL

30.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

20.06.05

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-748-201

Location: _____

PPP Rev: A

9/6/5

SL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 08/04/2009 9:15:51 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE AFT

Job Number: 47082

Part Number: D350748201

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/08 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-06-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

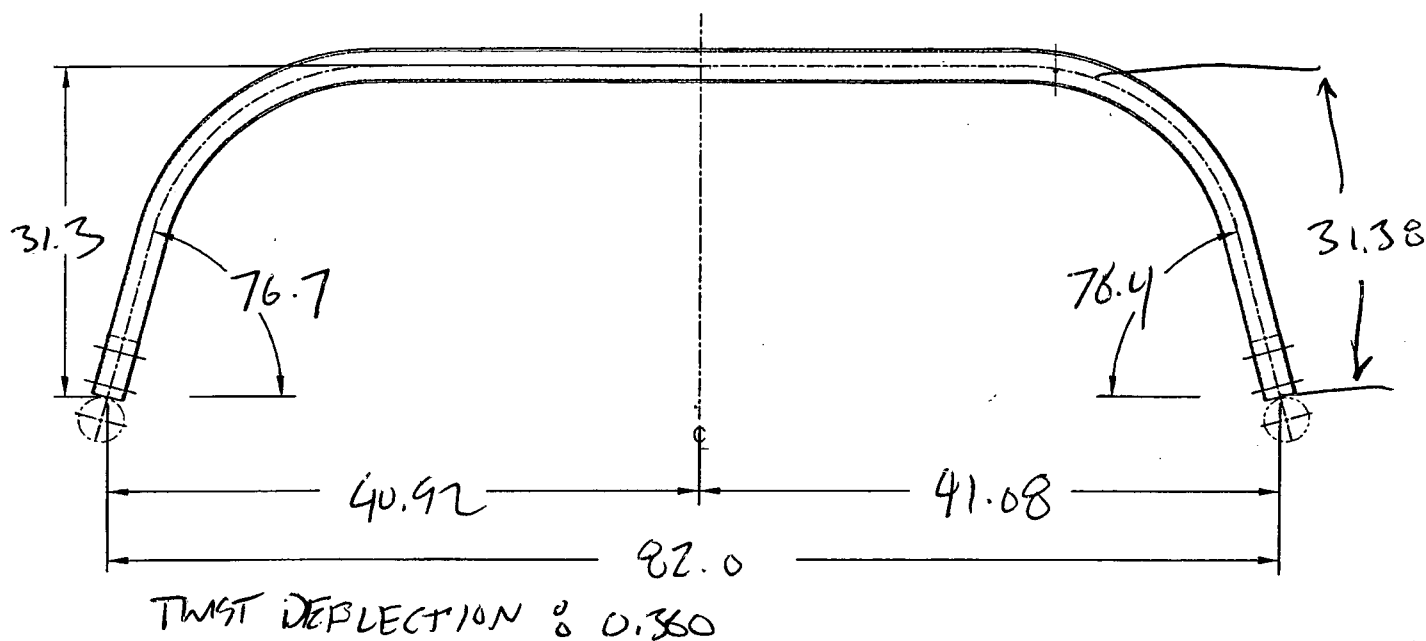
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	47082
Description: Crosstube High Aft (AS350/355)		Part Number:	D350-748-201
Inspection Dwg: D350-748-241 Rev: D		Page 1 of 1	

Required Dimension	Min	Max
Height	31.22	31.48
1/2 Span	40.77	41.03
Angle	75	77
Total Span	81.54	82.06



Comments
ONE SIDE BENT WIDE OK 09.04.23
TWIST IS OK 09.04.27

QC15 Inspection	09.04.23
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	



DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>///</i>	APPROVED <i>///</i>	DRAWING NO. D350-748-241	REV. D SHEET 1 OF 3
DATE 06.10.31		TITLE CROSSTUBE (AS 350/355 HI AFT) SCALE NTS	
A	06.03.31	NEW ISSUE	
B	06.06.30	ADD D6018-125 & PRIME AND PAINT	
C	06.08.14	ADD CAD PLATING	
D	06.10.31	MAG. PARTICLE AND CAD PLATE AS MFD.	

RELEASED

06.10.31 *///*

QTY	P/N	DESCRIPTION
X	D350-748-241	CROSSTUBE ASSEMBLY (AS 350/355 HI AFT)
1	D6018-125	CROSSTUBE (OR D6015-125)
2	D3502-1	SUPPORT
2	D2856-400-710	ABRASION STRIP
1	AELS-1032-225	INSERT
1	AN960JD10	WASHER
2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
1	MS27039-1-10	SCREW

D350-748-141 CROSSTUBE:

- 1) MATERIAL: MANUFACTURED FROM D6018-125 OR D6015-125
FINISHED LENGTH = 122.70±0.06
- 2) MACHINE PER MACHINING DETAIL ON PAGE 3. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITIONS SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 3) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 4) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 5) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING.
- 6) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 7) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 8) INSTALL D2856-400-710 ABRASION STRIP WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 9) TORQUE MS21920-20 CLAMPS 60 TO 80 IN-LB
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 11) ALL DIMENSIONS ARE IN INCHES
- 12) PART IS SYMMETRIC ABOUT CENTERLINE EXCEPT FOR Ø0.297 HOLE.

UNDER REVIEW

09.02.05
PER PCR #09-001

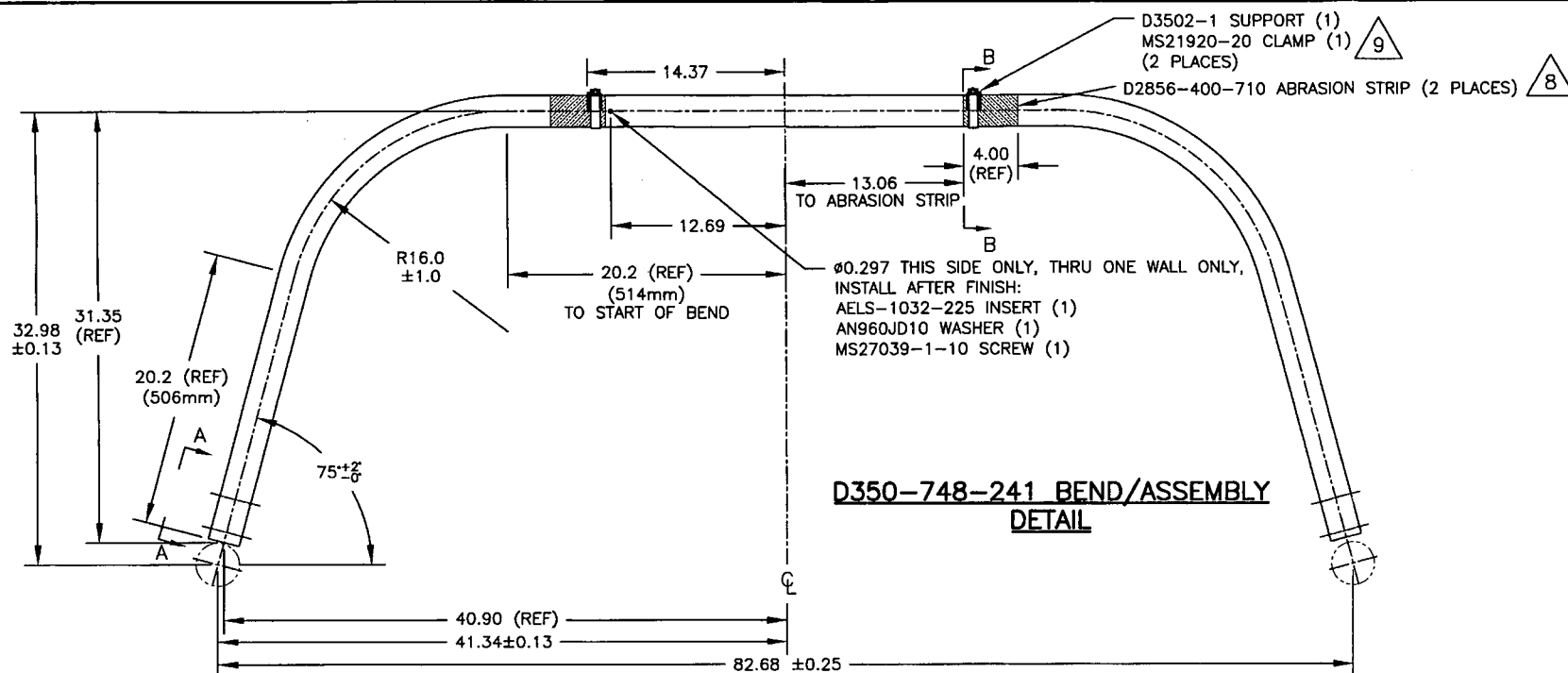
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WORK ORDER
NO. 127082

UNDER REVIEW

07.02.16
CUT FOR ASSEMBLY
OK 07.02.22

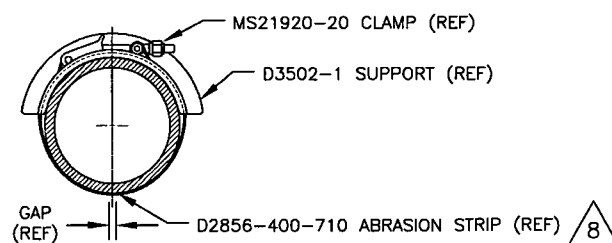
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**D350-748-241 BEND/ASSEMBLY
DETAIL**

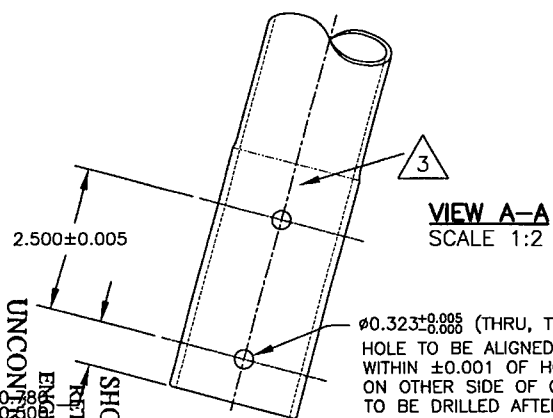
**SECTION B-B
SCALE 1:2**



UNDER REVIEW
09.02.05

UNDER REVIEW
07.02.06
OK 07.10.22

RELEASED
06.10.31



**VIEW A-A
SCALE 1:2**

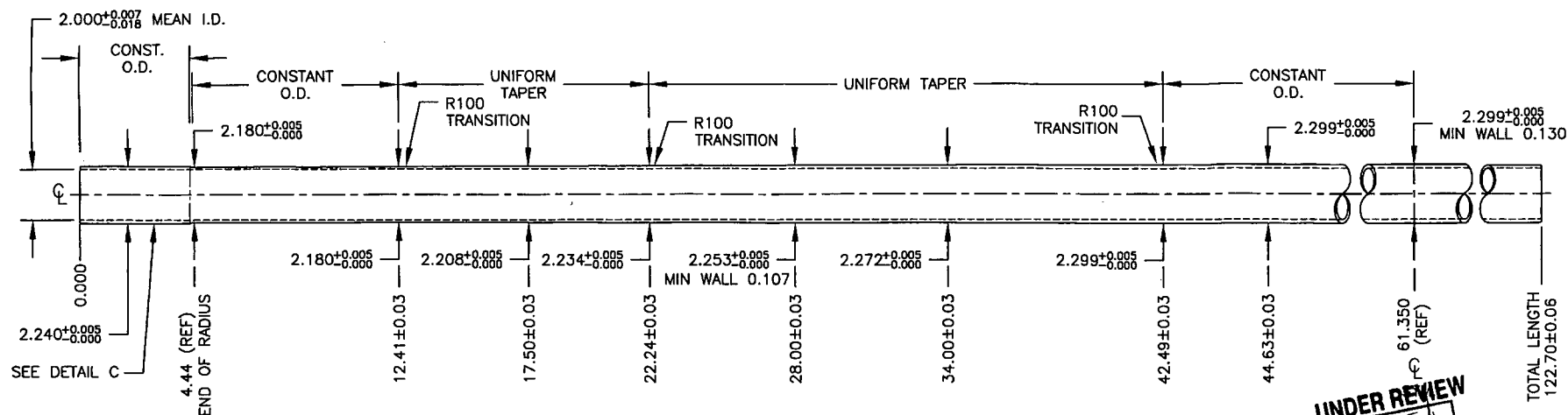
HOLE TO BE ALIGNED
WITHIN ±0.001 OF HOLE
ON OTHER SIDE OF CUFF,
TO BE DRILLED AFTER BENDING

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DESIGN	9	DRAWN BY	9	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO.	REV. D
DATE	06.10.31	TITLE	CROSSTUBE (AS 350/355 HI AFT)	D350-748-241	SHEET 2 OF 3
		SCALE	1:8		

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WORK ORDER
NO 4 28



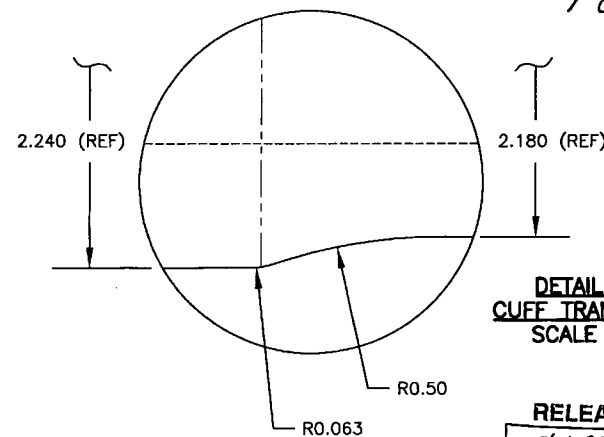
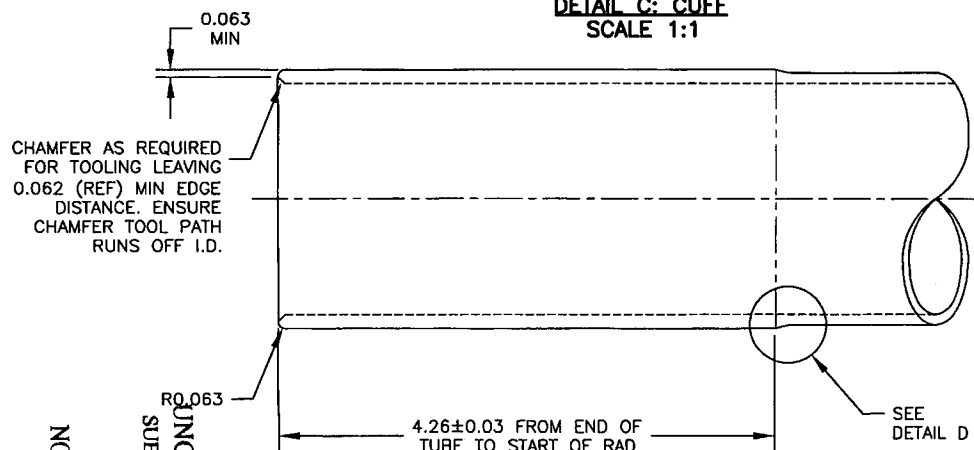
D350-748-241 MACHINING DETAIL

UNDER REVIEW
09.02.07

UNDER REVIEW

09.02.07
OK 07.10.22

DETAIL C: CUFF SCALE 1:1



DETAIL D: CUFF TRANSITION SCALE 9:1

RELEASED

06.10.31

NO. 108
WORK ORDER
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DESIGN qp	DRAWN BY qp	DART	DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D350-748-241	REV. D SHEET 3 OF 3
DATE 06.10.31	TITLE CROSSTUBE (AS 350/355 HI AFT)	SCALE 1:4	

**CERTIFICATE OF
CONFORMANCE**

**CADORATH PLATING CO. LTD.
2150 LOGAN AVENUE
WINNIPEG, MANITOBA R2J-0J1**

DATE: May-29-2009

**CONSIGNEE TO: Dart Aerospace Ltd.
1270 Aberdeen St.
Hawksbury, ON K6A 1K7**

**W/O #: 86268
INVOICE #: 44585**

**CONTRACT OR
PURCHASE ORDER #**

PO00008699

DESCRIPTION: SKID

P/N # D350-748-201

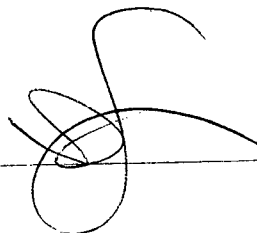
S/N # B47082

QTY 1

**STRESS RELIEF BAKE @ 375 FOR 5 HRS HEAT CHART #10438. MPI
INSPECTED IAW ASTM-E-1444. CADMIUM PLATED IAW AMS-QQ-P-
416B, TYPE 2 YELLOW, CLASS 1. BAKE HEAT CHART #10492.**

**CERTIFICATE: I certify that the items indicated here on have
been inspected and tested and conform to all specifications
and requirements detailed on the contract or purchase order.**

Approved Inspector:

A large, stylized handwritten signature in black ink.